

Date: Tuesday, 10/06/2008 12:54:38 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER AFT SADDLE
Job Number	: 39795		
Estimate Number	: 11080		
P.O. Number	:	Part Number	: D5955
This Issue	: 10/06/2008 S.O. No. :	Drawing Number	: D5955 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39605	Material	:
Written By	:	Due Date	: 30/06/2008 Qty: ¹² / ₈ Um: Each
Checked & Approved By	: <u>JLD 08.6.10</u>		
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101013	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: <u>B 40350</u>		
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5955, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble		
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:38 PM

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M108523



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
320.0 F
12:00

M-1 08/08/12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-12

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 491

JS 08/08/13

(12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/14

(12)

Job Completion



U 08-08-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39795
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	0.440"	0.440"	0.440"		
B	1.745	1.755		1.749	1.750"	1.750"	1.750"		
C	5.245	5.255		5.248	5.250"	5.250"	5.250"		
D	6.995	7.005		6.999	7.000"	7.000"	7.000"		
E	5.240	5.260		5.249	5.249"	5.249"	5.249"		
F	4.745	4.755		4.749	4.749"	4.748"	4.748"		
G	0.315	0.322		.322	.322	0.320"	0.320"		
H	1.522	1.532		1.525	1.524"	1.528"	1.528"		
I	3.048	3.058		3.056	3.057"	3.055"	3.055"		
J	4.575	4.585		4.581	4.579"	4.579"	4.579"		
K	0.315	0.318		.322	.322	0.322"	0.322"		
L	0.495	0.505		.500	.500	.500"	.500"		
M	0.490	0.510		.501	.501	.502"	.502"		
N	1.865	1.885		1.879	1.881"	1.875"	1.875"		
O	7.990	8.010		7.999	7.999"	8.001"	8.003"		
P	2.240	2.260		2.254	2.257"	2.257"	2.257"		
Q	0.307	0.312		.309	.309"	.309"	.309"		
R	0.760	0.765		.760	.760"	.760"	.760"		
S	0.490	0.510		.499	.504"	.505"	.505"		
T	1.625	1.645		1.632	1.634"	1.635"	1.635"		
U	2.000	2.020		2.006	2.008"	2.008"	2.008"		
V	0.023	0.043		.033	.033"	.033"	.033"		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>mf / J.F.</i>
Date: 08/08/10

Audited by: <i>J.P.</i>
Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 39795
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.249	5.249	5.249	5.249		
F	4.745	4.755		4.748	4.748	4.748	4.748		
G	0.315	0.322		0.320	0.320	0.320	0.320		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.055	3.055	3.055	3.055		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.318	0.318		0.320	0.320	0.320	0.320		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.502		
N	1.865	1.885		1.883	1.883	1.883	1.880		
O	7.990	8.010		8.003	8.003	8.003	8.003		
P	2.240	2.260		2.260	2.260	2.260	2.258		
Q	0.307	0.312		0.309	0.309	0.309	0.309		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.505	0.505	0.505	0.508		
T	1.625	1.645		1.636	1.637	1.634	1.632		
U	2.000	2.020		2.009	2.010	2.006	2.004		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	08/08/11

Audited by:	[Signature]
Date:	08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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F	08.04.21	Dimension E revised	KJ/DD	[Signature]

DART AEROSPACE LTD		Work Order: 39795
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.249	5.249	5.249	5.249		
F	4.745	4.755		4.748	4.748	4.748	4.748		
G	0.315	0.322		0.320	0.320	0.320	0.320		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.055	3.055	3.055	3.055		
J	4.575	4.585		4.579	4.579	4.579	4.579		
K	0.315	0.318		0.322	0.322	0.322	0.322		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.501	0.501	0.501		
N	1.865	1.885		1.884	1.884	1.884	1.884		
O	7.990	8.010		8.003	8.003	8.003	8.003		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.507	0.505	0.505	0.505		
T	1.625	1.645		1.636	1.636	1.635	1.634		
U	2.000	2.020		2.008	2.008	2.008	2.007		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

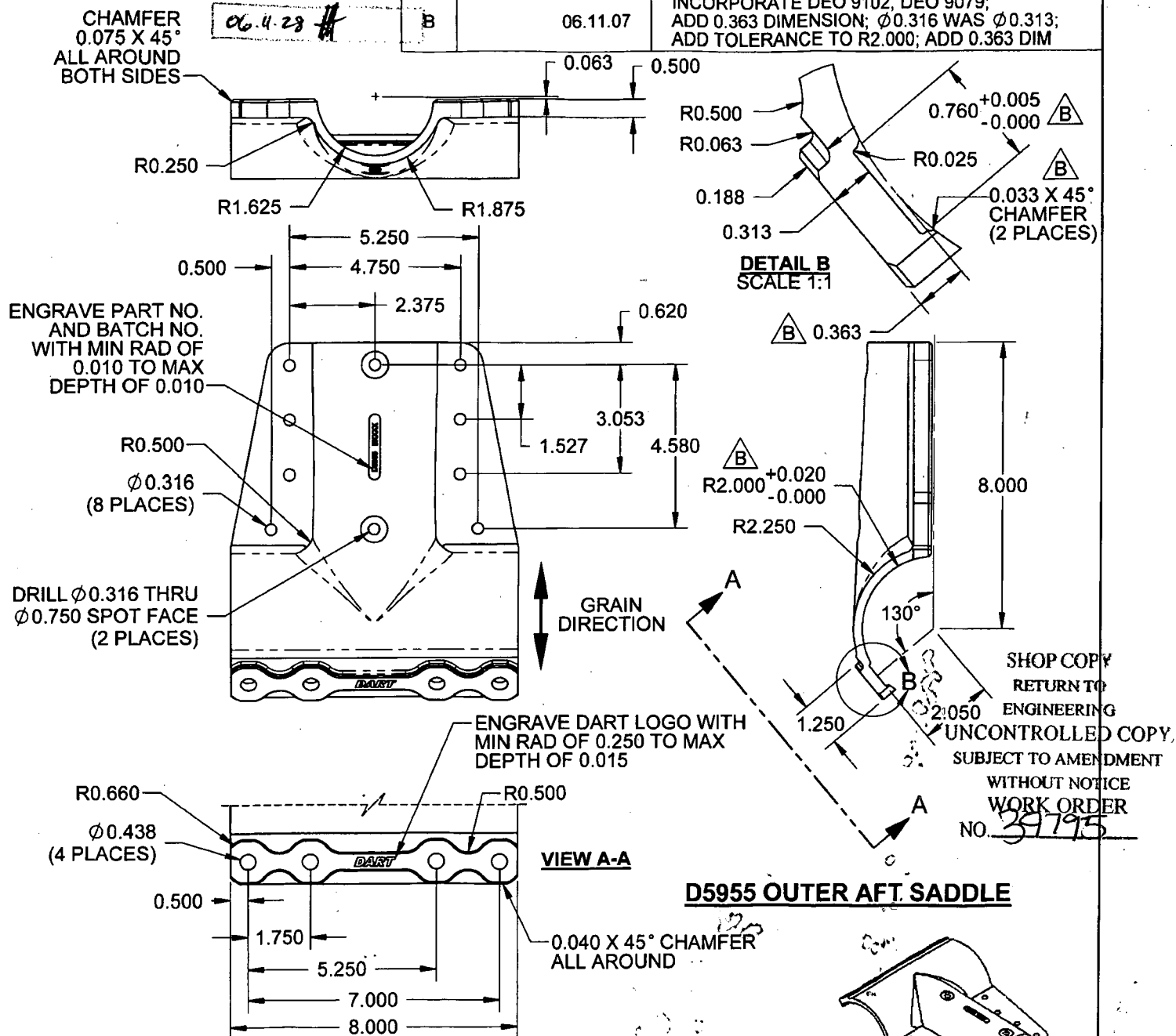
Measured by:	J.F. 08/08/11
Date:	

Audited by:	S.P.
Date:	08/08/11

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F	08.04.21	Dimension E revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 B
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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